

Date: Tuesday, 2/26/2008 8:02:27 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL ASSEMBLY
Job Number	: 37638 -1		
Estimate Number	: 12099		
P.O. Number	:	Part Number	: D3233041
This Issue	: 2/26/2008 S.O. No. :	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/	Drawing Revision	: B
Previous Run	: 35380	Material	:
Written By	: <u>080226</u>	Due Date	: 3/17/2008
Checked & Approved By	: <u>080226</u>	Qty:	10 Um: Each
Comment	: Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by half KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32335	Hub Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Hub Sleeve

Pick:

Qty Part Number	Description	Batch
1 D3233-5	Hub Sleeve	B35399 → 7 B37647 → 3

FF 08-05-28 (10)

WA 013

2.0	D32337	Shaft Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Shaft Sleeve

Pick:

Qty Part Number	Description	Batch
1 D3233-7	Shaft Sleeve	B35400 → 2 B37648 → 8

FF 08-05-28 (10)

WA 013

3.0	D32339	Tire & Rim Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Tire & Rim Assembly

Pick:

Qty Part Number	Description	Batch
1 D3233-9	Tire & Rim Assembly	B37649 → 2 B35436 → 3 B23726 → 4

FF 08-05-28 (10)

upstairs PK.

4.0	NKI 3020	BEARING
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)
Bearing

Pick:

Qty Part Number	Description	Batch
2 NKI 30/20	Bearing & Inner Sleeve	M107280

18 08/05/20 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 37638

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SHIM STOCK

.004" Brass Shim Stock



Comment: Qty.: 4.0000 f(s)/Unit Total: 48.0000 f(s)

.004" Brass Shim Stock

Pick:

Qty Part Number Description

Batch

4 Shim Stock 0.004" thick Brass Shim Stock

M107282

FF 08-05-28

(10)

6.0

35X45X7

Bearing Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bearing Seal

Pick:

Qty Part Number Description Batch

2 35x45x7 Axel Seal

M106075

or CR 35x45x7 HMS4 R

M107280

FF 08-05-28

(10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Press out bearings that are supplied with D3233-9 wheel and discard them.

Cut shims and assemble as per Dwg D3233

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.

FF 08-05-28

08-05-28

(10)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/28 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

4 - curl 6 - stones

08/05/29 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

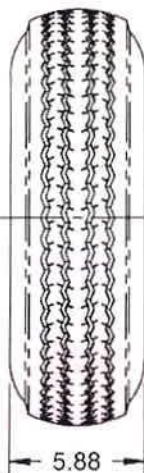
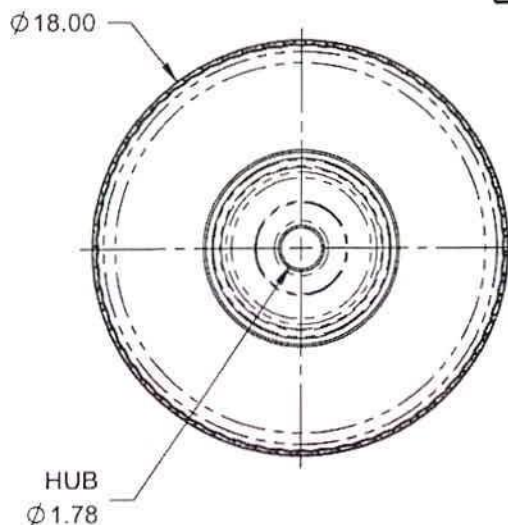
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

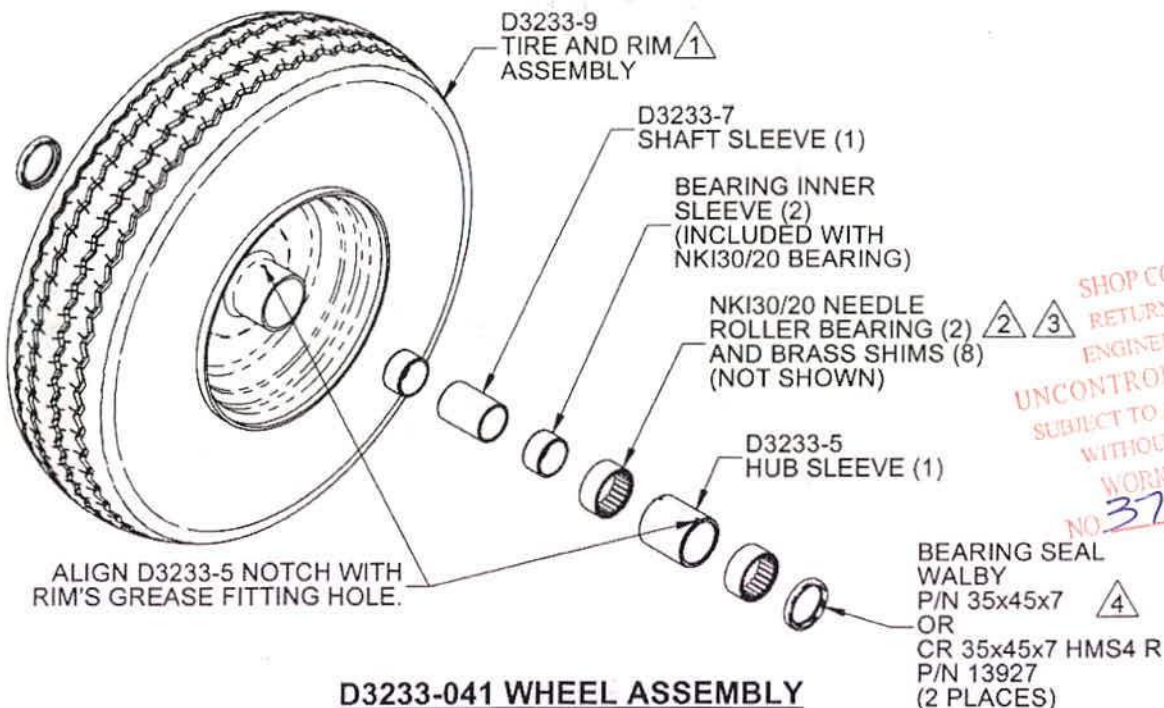


RELEASED
05/05/04

WHEEL SPECIFICATIONS

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

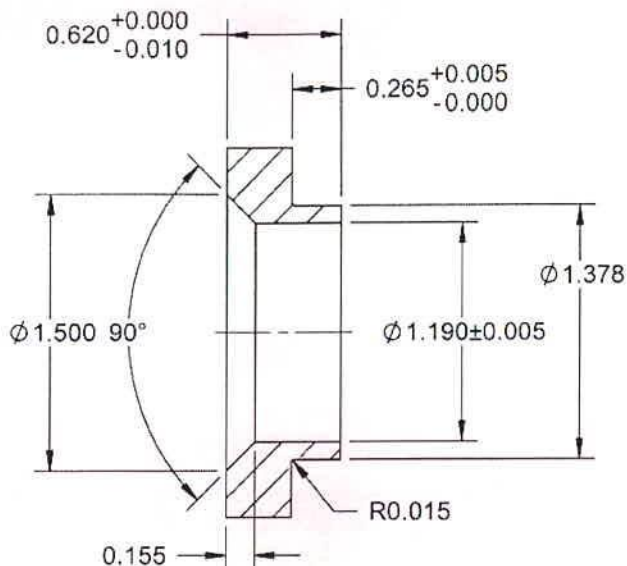
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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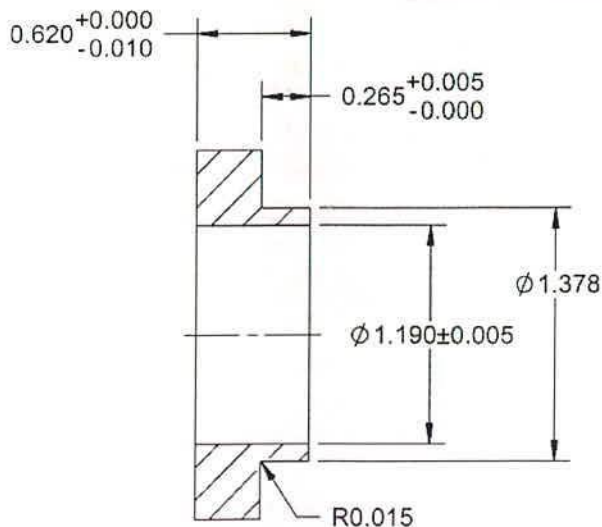
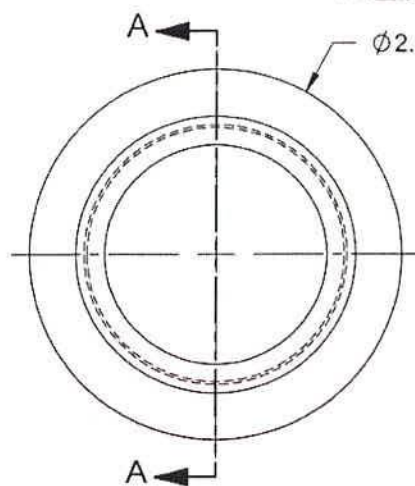


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



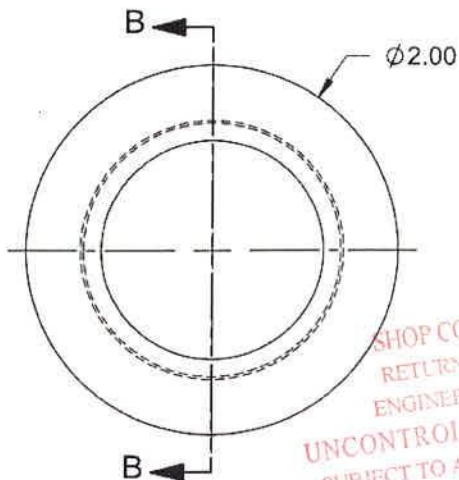
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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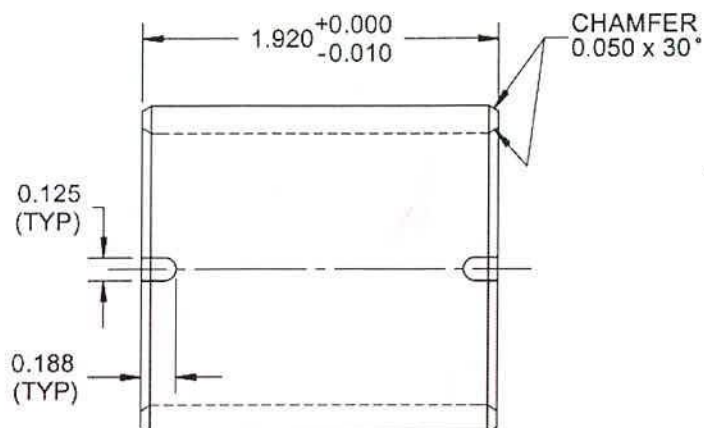
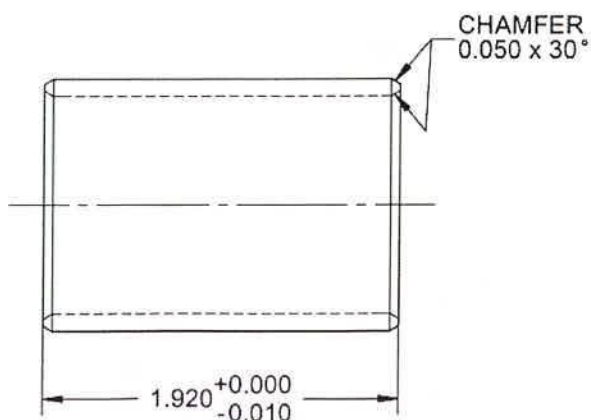
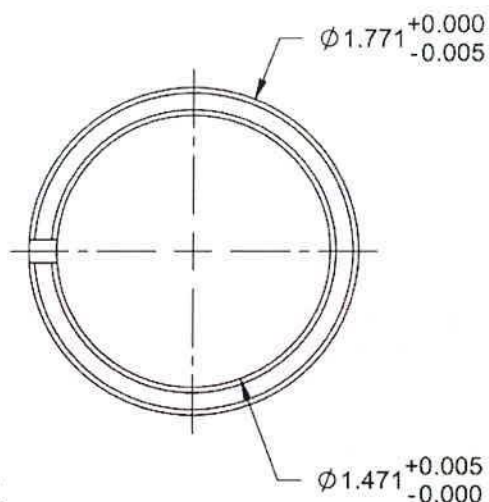
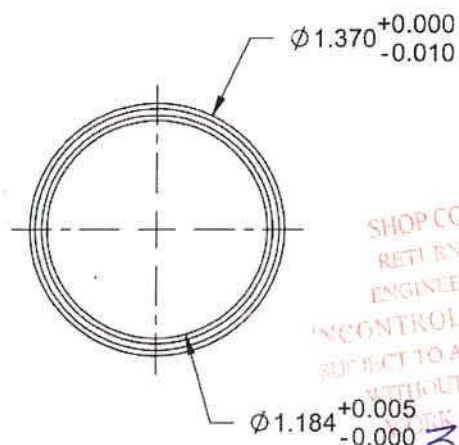
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WORK ORDER
NO. 37638

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE**

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37638

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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